Technical data sheet 011121MBA	Cored welding wire # CHROMECORE S 420-G	Welding Alloys

CLASSIFICATION

EN 14700: T Fe8

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding.
- 13% chromium martensitic air hardening stainless steel deposit.
- Suitable for use in presence of sulphurous gas
- Attractive bead appearance, automatic slag release, very good penetration and high productivity.
- Maximum performances in the horizontal and downhand positions.
- Welded with classical economical Ar-CO_2 mixtures.

APPLICATIONS

- Used for corrosion and wear resistant surfacing applications
- Surfacing of carbon steels to resist corrosion, erosion or abrasion, such as which occur in valve seats and other valve parts
- Preheat and post-heat treatments are required in order to achieve welds of adequate ductility

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni
0.3	0.6	0.8	13.0	0.5

Preheat temperature for multi-layer welding: min. 150°C
Maximum interpass temperature: 300°C

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness:
Weld deposit according to DIN 32525-4. As welded, 3-layers on mild steel; 48 - 52 HRc
The actual hardness for a given application depends on thermal history and dilution from parent material

SHIELDING GAS

M21 gas mixtures (Ar + 5 - 25% CO_2) or C1 (CO_2) according to EN ISO 14175.

OPERATING CONDITIONS

Diameter [mm]	Current type	Intensity [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.2	DC+	100 - 280	23 - 33	10 - 25	12 - 20 l/min.
1.6	DC+	150 - 400	23 - 35	10 - 25	12 - 20 l/min.

WELDING POSITIONS

EN ISO 6947: PA, PB.
ASME IX: 1G, 1F, 2F.

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M	
Spool type	BS300	
Weight	15 kg	

Other packaging and other diameters: please consult us